

WORK ORDER 2011-16

Date opened: 01 March 2011

Project: Quick Release Cargo Basket Assembly
Type: Eurocopter AS350/355 SeriesBatch Quantity: 5 Complete Basket Assembly (76410-01)
Left Hand Configuration
Stainless Steel Construction
4 Modified with Open Front End (70406)
5 Modified with Lid Step (70405)Approval: SH08-16
Drawing List: DCL764-3

Fabrication and Assembly Drawing(s)	Description
76410, Rev. 2	Basket Ass'y
76411, Rev. 2	Basket Body Ass'y
69812, Rev. 1	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 4	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 2	Lid Step Modification
70406, Rev. 1	Front End Cutout Modification
EO926.90	

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	<u>Y</u>
Document Control List revision level matches (or exceeds) STC:	<u>Y</u>
Drawings revision levels match Document Control List:	<u>Y</u>
Purchase order or Work order source is recorded for each part/ass'y:	<u>Y</u>
Tests and inspections specifically called out on drawings are complete:	<u>Y</u>
Release tags associated with all fabricated parts are attached:	<u>Y</u>
All mounting hardware and supplies are included:	<u>Y</u>

List all non-conformities raised: _____

Welder Signature: _____ Date: _____

Inspector Signature: _____ Date: _____

Drawing: **76410** Revision **2**
 Assembly: **76410-01** **Cargo Basket Ass'y (Quick-Release, Medium, 75.75" long)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	76410-01	Cargo Basket Assembly			
. 1	76411-01	Basket Body Assembly	Below		
. 1	69812-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace	8093	
. 1	MS20001P4	Piano Hinge		11014	
. 1	76427-01	Placard	0.063 Sheet, 6061-T6 Aluminum	10086	
. 3	49205-14	Bumper	Argus Industries Bumper	11010	
. 4	HR3213-4-02	HuckMax Rivet		10089	
. 8	HR3523-5-02	HuckMax Rivet		11061	
. A/R	HR3213-5-02	HuckMax Rivet		10089	
. 4	40088-14	Fitting	Ancra	11012	
. 4	AN960-616	Washer		11077	
. 4	AN960-616L	Washer		11025	
. 1	AN3-15A	Bolt		7077	
. 1	AN3-17A	Bolt		10125	
. 4	AN960-10	Washer		11025	
. 2	AN970-3	Washer		11052	
. 2	MS21044N3	Nut		11025	

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B			
Final Inspection	Drawing 76410			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **76411** **Revision 3**
 Assembly: **76411-01** **Basket Body Ass'y (Quick-Release, Medium, 75.75" long)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	76411-01	Basket Body Assembly			
. A/R		Tube	304 Stainless, 3/4" x 0.049 Sqr. Tube	10128	
. A/R		Tube	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 3	76421-01	Hoop	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 1	76422-01	Attachment Hoop	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 1	76423-01	Attachment Hoop	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 1	36262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	304 Stainless, 1/2" Rod	8096	
. A/R	3/4-16F	Mesh	Expanded stainless steel	11001 11032	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 76411			
Final Inspection	Drawing 76411			

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Drawing: **69812** **Revision 2**
 Assembly: **69812-01** **Basket Lid Ass'y (Quick-Release, Medium, 75.75" long)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	69812-01	Basket Lid Assembly			
. 2	69824-01	Rim	304 Stainless, 3/4" x 0.049 Sqr. Tube	10128	
. 2	49212-01	Rim	304 Stainless, 3/4" x 0.049 Sqr. Tube	10128	
. 3	49213-01	Rim	304 Stainless, 3/4" x 0.049 Sqr. Tube	10128	
. 1	49216-01	Spacer	304 Stainless, 1/2" Rod	8096	
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	304 Stainless, 0.035" Sheet	3021	
. A/R	3/4-16F	Mesh	Expanded stainless steel	11001-11032	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Powder Coat	Drawing 69812			
Final Inspection	Drawing 69812			

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Drawing: 84255 Revision 0
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
5 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	11041	
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia	11030	
. 2	84267-01	Bracket	Delrin, 0.75" Sheet	WO 2011-20	
. 2	AN3-12A	Bolt		10125	
. 4	AN3-11A	Bolt		11052	
. 10	AN960-10	Washer		11028	
. 6	MS21044N3	Nut		11028	

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

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Drawing: 84261 Revision 0
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
5 Total	84261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube	11057	
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet	10036	
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
. 2	MS20615-4M3	Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

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Drawing: **84262** **Revision 0**
Assembly: **84262-01** **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	304 Stainless, 5/16" x 0.058 tube	8065	
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
. 2	36275-02	Support	304 Stainless, 5/16" Rod	8065	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

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Drawing: 70406 Revision 0
Assembly: 70406-01 Open Front End Modification

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
4 Total	70406-01	Open Front End Modification			
. 1	70406-03	Tube	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 1	70406-04	Tube	304 Stainless, 1/2" x 0.049 Sqr. Tube	10128	
. 1	3/4-16F	Mesh	Expanded Stainless Steel	11001 11032	

Note: Remainder of assembly listed on drawing 76410

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70406			

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Drawing: **70405** **Revision 0**
Assembly: **70405-01** **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 Total	70405-01	Lid Step Modification			
. 1	70405-03	Tube	304 Stainless, 3/4" x 0.049 Sqr. Tube	10128	
. 1	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	11055	
. A/R	CR3213-4-2	Cherry Rivet		10089	

Note: Remainder of assembly listed on drawing 69812.

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

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